Work Orde February-24-14					Page 1							
Item ID: Revision ID:	D3393-041			Accept	*N900	<u> </u>	100	)*	Setup	Start	*N	S1*
Item Name:	Battery Lock									Stop	*N	S2*
Start Date:	2/24/14	Start Qty: 2.00	*2*		Cust Item	ID:						
Required Date: Reference:	: 2/24/14	Req'd Qty: 2.00	*2*		Customer	:						
Approvals:	Process Pla	in: ML5	Date: 14-02-2	Tooling:	I	Date:	_		Run	Start	*N	R1*
	QC:	<b>,</b>	Date:	SPC (Y/N):	I	Date:				Stop	*N	R2*
Sequence ID/ Work Center I	<b>D</b> ,	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty	-	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3393	Rev	Α										_
100			4.6	0.00				_				FF
*100* Small Fab		Small Fab  Memo		0.00				. 2				14-03-
Small Fab		ATTN: - C 1-Open D: and lock b per Dwg I	CHECK IF KEYED ALIKE (3373-1 lock package. Keep harrel. Discard the rest.2-Usi) 03369Identify as D3369-53-usert lock body and fasten	OR KEYED DIFFERENT keys, lock body, lock bod ing the flat cam, fabricate	ly nut, flat cam D3369-5 as							
110				0.00								
*110* Large Fab		Large Fab Memo		0.00					10	I-03-	06_	<b>D</b>

Large Fab

Tack Weld lock shaft to flat cam of a Max 1/8" Long QtyPart Number Description Batch A/RN/A SS Rod 11/3233

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		Vork Order u	odate only	AEROSPACE		
						DISPOSITION					EPARTMENT	· .	1		
Work Orde	er: .						. 1				<b>-</b>				
	_					Rework		Skid-tube Crosstube				Water Jet	Engineering		
Part i	10.					Scrap		Machining Small Fab				d. Eng. Coor.	Quality		
NCD						Use-as-is			noforming	Finishing	- Rec/Sto	re/Packaging	Other		
NCR I	NO.	<u>-</u> .				Suspected Unapproved	1		Large Fab	Composite _		Supplier			
Root					Desc	ription of work order update		nitial	Act	tion	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng Description			Date	Verification	QC Inspector		
Design															
Doc/Data							1								
Equip/Tooling															
Handling/Pre	/Pre														
Material															
Operator															
Offset/Setup															
Process	Щ														
Supplier	lacksquare				1										
Training	-						· ·								
Transport	$\vdash$		ļ												
Unapproved			1	<u> </u>	<u> </u>		EAL	III T CAT	TEGORY			<u> </u>			
Londi						General	FA	OLI CA	IEGORY				. ,,,,,		
Landi	LIB (	Bending				Bend		احمانه/5	Program	Г	Outside Din	ensions [	Pressure/Forced		
	-	Centre No	nt Concer	ntric	-	BOM/Route	$\vdash$	Grain	rogram	F	Over/Under	<u> </u>	Set-up		
	$\vdash$	l	J. COIICEI	THE IC		Broken/Damage/Defect	-	Hardwa	are	F	Part Incorre	<del>-</del>	Temperature/Cure		
	Cracks Crimp/Kink/Ripple/Wave					Burrs	<u> </u>	4	ion Incomplete/U	ngualified	Part Lost/M	_	Weld		
	Cuffs Cuffs					Contamination		1 .	tions Incomplete/		Part Moved		Wrong Stock Pulled		
	Crushing					Countersink		4	gned/off center		Positioned				
	Heat Treat					Cut Too Short		Mislabe		l l	Power Loss,		Other		
	Inspection Strip in Tube					Drawing		Misrea		L		· L			
	Marks/Chatter					Drill Holes		Off-set					•		
	Turning Sequence					Finish	Out of Calibration								
	Wave/Twist in Tube					Fit/Function		Out of Sequence							

Work Orde February-24-14				*113730*								
Item ID: Revision ID:	D3393-041			Accept	*N900	<b>040</b>	100	)* s	Setup Sta	í A	S1*	
Item Name: Battery Lock Stort Date: 2/24/14 Stort Otrus 2 00									Sto	φ *N	S2*	
Start Date:	2/24/14	Start Qty: 2.00	*2*		Cust Item I	D:						
Required Date:	Req'd Qty: 2.00		*2*		<b>Customer:</b>					į.		
Reference:		-										
Approvals: Process Plan:			Date:	Tooling:	Da	ate:		F	Run Sta	^ I/J	R1*	
	QC:		Date:	_ SPC (Y/N):	Da	ate:	····		Sto	<sup>'p</sup> *N	R2*	
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
120		QC9- Inspect visual per	QS1004- Fusion Welds	0.00								
*1 20* QC Quality Control		Memo		0.00				_2	<u>a</u>	J4-3-	6	
130			·	0.00				a			FF	
*120* Small Fab		Small Fab  Memo		0.00				_2			14-030	
Small Fab		Apply Craz Batch: M	y Glue to cap and press 1 <b>2.</b> 6240	epply bobd	5 · ·	·						
140 QC5- Inspect part completer		leteness to step on W/O	0.00 <b>27</b>				$\sim$					
140 QC3- Inspect part complete			9 <del>/</del> 89 <sub>\</sub>				$\cap$					

\*140\*

Quality Control

Memo

DQA:			Date:		· -	WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON-	-CC	OHO	RMANCE / UI		۱۸/،	ork Order up	ndate only	AEROSPACE	
QA Closed.		<del></del>	Date.				-		<del>.</del>		-	ork Oraci ap	date only	<del></del>	
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
	•				_	Rework			Skid-tube	Crosstube			Water Jet	Engineering	
Part N	lo.					Scrap		1	Machining Small Fab			Pro	d. Eng. Coor.	Quality	
	•					Use-as-is		Thermoforming Fini				Rec/Stor	e/Packaging	Other	
NCR N	lo.					Suspected Unapproved	proved Large Fab Composite					Supplier			
2	-1				Daga	:	ᅼ	nitial	A at	ion		T c: 0		<u> </u>	
Root		Data	Ston	Otv	Desci	ription of work order update or non-conformance	l	nitial Action ief Eng Description				Sign & Date	Verification	QC Inspector	
Cause	$\dashv$	Date	Step	Qty		or non-comormance	Cii	Description				Date	Vermeation	QC IIISPECTOI	
Design Doc/Data	$\dashv$														
Equip/Tooling					i										
Handling/Pre															
Material															
Operator		4					1								
Offset/Setup		ı													
Process				i											
Supplier												}			
Training															
Transport							1								
Unapproved													·		
							FA	ULT CA	TEGORY						
Landi	ng (	Gear				General		1		,		7	_	<del></del>	
		Bending				Bend	_	4 .	Program			Outside Dim	<u> </u>	Pressure/Forced	
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain			_	Over/Under	-	Set-up	
		Cracks				Broken/Damage/Defect	<u>_</u>	Hardwa			_	Part Incorre	-	Temperature/Cure	
	Crimp/Kink/Ripple/Wave					Burrs	⊢	4	ion Incomplete/U	-	<u> </u>	Part Lost/Mi		Weld	
	Cuffs					Contamination	<u> </u>	4	tions Incomplete/I	Unclear	$\vdash$	Part Moved	_	Wrong Stock Pulled	
	Crushing					Countersink	$\vdash$	-{ '	gned/off center		$\vdash$	Positioned V		Tother	
	Heat Treat					Cut Too Short	$\vdash$	Mislabe				Power Loss/	ourge [	Other	
	Inspection Strip in Tube					Drawing Drill Holos	$\vdash$	Misrea						***	
	Marks/Chatter					Drill Holes	Off-set Out of Calibration								
	Turning Sequence					Finish Fit/Function	$\vdash$	-1	Sequence			<del></del>		· · · · · · · · · · · · · · · · · · ·	
I	Wave/Twist in Tube					prigranicaon	1	Jour of	Jequence						

Work Orde February-24-14					Page 3								
Item ID: Revision ID: Item Name:	D3393-041 Battery Lock			Accept	*N900	100	<b>)*</b> Setup		Start Stop	*N.S		<del></del>	
Start Date: Required Date: Reference:	2/24/14 2/24/14	Start Qty: 2.00 Req'd Qty: 2.00	*9*		Cust Item ID: Customer:							.,	
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ate:		]	Run	Start Stop	*NF		
Sequence ID/ Work Center II 150 *1 5 0* Packaging Packaging	D	Operation Description Identify as per dwg & St  Memo	ock Location: ST 49%	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty			Insp. Stamp	DAS 26 9-89
160 *1 AO* QC Quality Control		QC21- Final Inspection	- Work Order Release	0.00				—-М	L <del>I</del>		1403 VIII	71 -3-10	- )

DQA:		<del></del>	Date:	WORK ORDER NON-CONFORMANCE / UPDATE											
QA Closed:			Date:			WORK ORDER NON-	-00	NALOI	VIAIWIACE \ O		ork Order up	date only	AEROSPACE		
Work Orde	or.					DISPOSITION		·		AGAINST D	EPARTMENT/	RTMENT/PROCESS			
Part N	•					Rework Scrap		Skid-tube Crosstub  Machining Small Fa			-1	Water Jet d. Eng. Coor	Engineering Quality		
NCR I	۱o. ِ			-		Use-as-is Therr Suspected Unapproved			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other		
Root					Desci	ription of work order update	ı	nitial	Act	tion	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre						·									
Material															
Operator															
Offset/Setup							l			•					
Process															
Supplier							Ì		1						
Training									ļ						
Transport															
Unapproved															
							FA	ULT CA	regory						
Landi	ng (	Gear				General		1		_	_		<b></b> 1		
		Bending				Bend		•	Program		Outside Dim	<u> </u>	Pressure/Forced		
		Centre No	ot Concer	ntric		BOM/Route		Grain		<u> </u>	Over/Under		Set-up		
		Cracks				Broken/Damage/Defect		Hardwa		L	Part Incorred	<b>├</b>	Temperature/Cure		
		Crimp/Kir	rk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Part Lost/Mi	ssing	Weld		
,		Cuffs				Contamination		4	tions Incomplete/	<del>-</del>	Part Moved	<u> </u>	Wrong Stock Pulled		
	Crushing					Countersink	-	1	gned/off center	_	Positioned V		7		
	Heat Treat					Cut Too Short	<u></u>	Mislabe			Power Loss/	Surge	Other		
	Inspection Strip in Tube					Drawing	L	Misrea				,			
	Marks/Chatter					Drill Holes		Off-set							
	Turning Sequence					Finish		1	Calibration						
	Wave/Twist in Tube					Fit/Function		Out of Sequence							

February-24-14 10:02:21 AM

Work Order ID: 113730

\*113730\*

D3393-041

\*D3393-041\*

Parent Item Name: Battery Lock

**Parent Item:** 

**Start Date: 2/24/14** 

Required Date: 2/24/14

Start Qty: 2.00

Required Qty: 2.00

									<b>Julie Quy. 2</b> .00		11040111	Z Q C J C Z	
Comments:	IPP Rev:A N	ew Issue 05-	11-22	JLM									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16WC		Purchased	No		,	100	Each	469.0000	2	4			
*5/16WC*	•								**		FF	14-	03-04
				Location	!	Loc	Oty	Loc Code					
				ST365			469		<u> </u>	- 2/	_		
05671/01					M127961	100	469	15,0000		7	_		
9567K21	_	Purchased	No			100	Each	15.0000	2	-4	/		
*9567K21 Polyetheline Cap	*								**		FF	14-	03-06
				Location	l	Loc	Oty	Loc Code					
				ST381			15				_		
D3373-1		Manufactured	No		120743	100	15 Each	32.0000	1	<del>7</del>	_		
	J.	Manufactured	NO			100	Lacii	32.0000	**	2	FF		<b>-</b>
*D3373-11	*									····	<u> </u>	19-0	3-04
				Location	!	Loc	Oty	Loc Code					
				GA			26		_	Ø)	_		
				amo to	105986		26		′ <del>-</del>		_		
				ST040	74862		6 6		_		_		
D3393-1		Manufactured	No		74002	100	Each	4.0000	1	2	_		
*D3393-1* Battery Lock Casing	*	Manaractured							**		FF	14-0	3-04
				Location	<u>l</u>	Loc	Oty	Loc Code					
				ST492			4		_				
					102336		4		-	<u> </u>	_		

DQA:			Date:													
						WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE	14	I. OI		AEROSPACE			
QA Closed:		**	Date:					Work Order update only								
Work Orde	r:					DISPOSITION			AGAIN	NST DEPARTMENT/PROCESS						
Work Orac	-					Rework	ıl		Skid-tube Crosstul	oe 🗀	1	Water Jet	Engineering			
Part N	lo.					Scrap		Machining Smal			Pro	d. Eng. Coor.	Quality			
	•					Use-as-is			noforming Finishi	_	4	re/Packaging	Other			
NCR N	lo.					Suspected Unapproved			Large Fab Composi	te	]	Supplier				
D 4					Doss	vintion of work order undate	Н	Initial Action			Sign &		1			
Root		Data	Cton	O+14	Desci	ription of work order update or non-conformance	1	nitial ief Eng			Date	Verification	QC Inspector			
Cause	$\dashv$	Date	Step	Qty		or non-comormance	CII	iei ciig	Description		Date	Vernication	Qe mapeetor			
Design Doc/Data	_															
Equip/Tooling	ing															
Handling/Pre																
Material																
Operator	╗						١									
Offset/Setup												;				
Process																
Supplier													}			
Training				1			Ì		·							
Transport																
Unapproved			<u> </u>								<u> </u>		<u> </u>			
							FA	ULT CA	TEGORY							
Landi		t			_	General	_	1		_	7		٦. , .			
		Bending			<u> </u>	Bend	<u> </u>	1	Program	$\vdash$	Outside Dim	<u> </u>	Pressure/Forced			
		Centre No	ot Concer	ntric	_	BOM/Route	<u> </u>	Grain		$\vdash$	Over/Under	<u> </u>	Set-up			
		Cracks		6	<u> </u>	Broken/Damage/Defect	$\vdash$	Hardwa		-	Part Incorre	_	Temperature/Cure			
		Crimp/Kir		Burrs	$\vdash$	1	tion Incomplete/Unqualified	$\vdash$	Part Lost/M	· -	Weld Wrong Stock Pulled					
		Cuffs Contamination Countersink					$\vdash$	4	tions Incomplete/Unclear	$\vdash$	Part Moved Positioned V	_	T ANTONIS STOCK Lanea			
	_	Crushing			-	Cut Too Short	-	Mislab	gned/off center	-	Power Loss/	_	Other			
	_	Heat Trea		Tubo	$\vdash$	Drawing	-	Misrea		L	Trower ross/	Juige [	Joures			
	<del> </del>	Marks/Ch	•	Tube	-	Drill Holes		Off-set								
l	Turning Sequence Finish					Out of Calibration										
						Fit/Function	Out of Sequence									
	Wave/Twist in Tube					•		1								

**Picklist Print** 

February-24-14 10:02:21 AM

\_\_\_\_\_

Work Order ID: 113730

Parent Item:

D3393-041

Parent Item Name: Battery Lock

\*113730\*

\*D3393-041\*

**Start Date:** 2/24/14

Required Date: 2/24/14

Start Qty: 2.00

\*\*

Required Qty: 2.00

D3393-3

Manufactured

No

140

Each

23.0000

Loc Code

.

14-03-04

Page 2

\*D3393-3\*

Cam Lock Shaft

<b>Location</b>	Loc Oty
ST041	23
101110	1
108529	10
109126	12

\_\_\_\_

DQA:			Date:														
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPD			<del></del>	AEROSPACE				
QA Closed:			Date:					Work Order update only									
Work Orde	or.	٠,				DISPOSITION				PROCESS							
WOIR OIG	-''-			_		Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering				
Part N	lo.					Scrap			Machining	Small Fab	Prod	d. Eng. Coor.	Quality				
, 4, 4,	-					Use-as-is			noforming	Finishing	4	e/Packaging	Other				
NCR N	۱o.					Suspected Unapproved			~ —	Composite	]	Supplier					
_									T	<del></del>	] c: 0						
Root	i			۵.	Desci	ription of work order update	ì	nitial	Action		Sign &	\/:E: A:	OC In an a stan				
Cause	_	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	QC Inspector				
Design	$\vdash$																
Doc/Data	$\dashv$																
Equip/Tooling							}										
Handling/Pre Material	$\dashv$																
							ļ										
Operator Offset/Setup	$\vdash$																
Process	$\vdash$	i															
Supplier	H																
Training																	
Transport																	
Unapproved		!	ļ														
							FA	ULT CA	TEGORY	-							
Landi	ng G	Gear				General		_		_	_		<del>-</del> 3				
		Bending				Bend	L	Folio/F	Program		Outside Dim	<u> </u>	Pressure/Forced				
		Centre No	ot Concer	ntric		BOM/Route	L	Grain		<u> </u>	Over/Under	<del> </del>	Set-up				
 		Cracks			_	Broken/Damage/Defect	<u></u>	Hardwa		ļ	Part Incorred	<u> </u>	Temperature/Cure				
		Crimp/Kir	nk/Ripple	/Wave		Burrs		-1 `	ion Incomplete/Unqu	<del></del>	Part Lost/Mi	ssing	Weld				
	Cuffs					Contamination		-	tions Incomplete/Und	clear	Part Moved		Wrong Stock Pulled				
	Crushing					Countersink	_	-	gned/off center	<u> </u>	Positioned V		٦				
	Heat Treat					Cut Too Short		Mislab		L_	Power Loss/	Surge	Other				
}	Inspection Strip in Tube					Drawing	<u></u>	Misrea									
ł	Marks/Chatter					Drill Holes	<b> </b>	Off-set									
	Turning Sequence					Finish	<u> </u>	-i	Calibration				<del></del>				
1	Wave/Twist in Tube					Fit/Function		Out of Sequence									